

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011626**Date Inspected:** 09-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG Segment 12BW, weld No.SEG3005L-005. The welder is identified as #058242. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR-1.The weld repair report was B-WR-9542.

SAW in the 1G position for the OBG Segment 12BW, weld No.SEG3005A-004. The welder is identified as #048686. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 3G position for the OBG Segment 11EW, weld No.SSD13-PP108-135. The welder is identified as #202122. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3G position for the OBG Segment 11EW, weld No.SSD13A-PP108-131. The welder is identified as #201215. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

with WPS-B-T-2233-B-U2-F.

OUT SIDE YARD

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 9DW, weld No.SSD10A-PP80-226. The welder is identified as #207465. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F-1.

FCAW in the 4G position for the OBG Segment 9DW, weld No.OBW9E-13. The welder is identified as #0468097. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

During in-process observations of the side panels being fabricated in bay 14, the Caltrans Quality Assurance Inspector (QA) observed that ZPMC personnel perform a Critical Weld Repair (CWR) without the Engineers approval. The repair being performed was weld buildup (buttering). The amount of buttering is approximately 18mm. The material is 16mm thick A709 Grade 345 Seismic Performance Critical Material (SPCM). The Side Panel is identified as SP3004C for lift 12AE. The plate number is identified as PL-3052E.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
